

Date: Monday, 16/10/2006 7:47:54 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET, GAS SPRING
Job Number	: 28949		
Estimate Number	: 10179		
P.O. Number	: <i>N/A</i>	Part Number	: D2144
This Issue	: 16/10/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2144 REV. D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 16/10/2006 Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 28976	Material	: <i>N/A</i>
Written By	:	Due Date	: 19/10/2006 Qty: 40 Um: Each
Checked & Approved By	:		
Comment	: Est: 04.05.06 Reformat KJ/RF		
	: Est Rev:E Now on Waterjet 06-10-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0945 sf(s)/Unit Total : 3.7800 sf(s)

304/316 .063 Sheet 16GA

Batch: *M101463*

M 06/10/17

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2144

Dwg Rev: *D*

Prog Rev: *D*

M 06/10/17

(42)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06/10/17

(42)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Job 10-20 counted

(42)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

on F. 06/10/24

(42)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET, GAS SPRING

Job Number: 28949

Part Number: D2144

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2144

Rev: D

SB 06/10/24

(42)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20.10.24 (42)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FAB RESOURCE 1

1- Weld corner as per Dwg D2144 & QSI 004

2- Grind flush

PD

06-10-24

(42)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/10/25 42

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20.10.25

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

06/10/26 x 42

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/10/26

(42)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51218

06/10/26

(42)

c 206/10/27

Date: Monday, 16/10/2006 7:47:55 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET, GAS SPRING

Job Number: 28949

Part Number: D2144

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(42)

Comment: FINAL INSPECTION/W/O RELEASE

1706/10/27

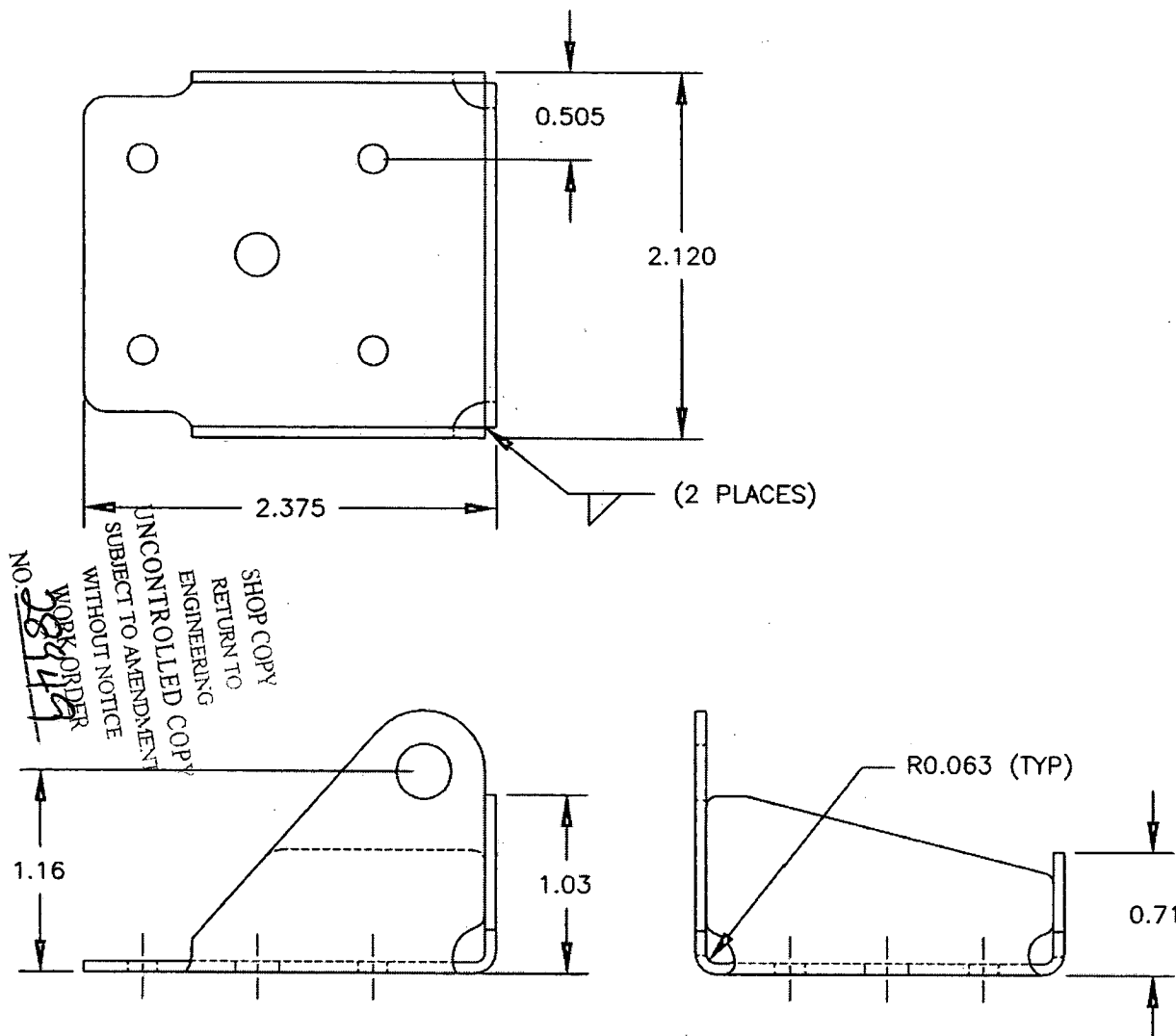
Job Completion





RELEASED
48.10.15 AE D

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. D
BW	AE	DRAWING NO.	D2144	SHEET 1 OF 2
CHECKED MA	APPROVED AE	TITLE	HINGE BRACKET	SCALE 1:1
DATE 98.10.08				
A	95.03.17	NEW ISSUE		
C	96.06.05	FLAT PATTERN LAYOUT ADDED		
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)		



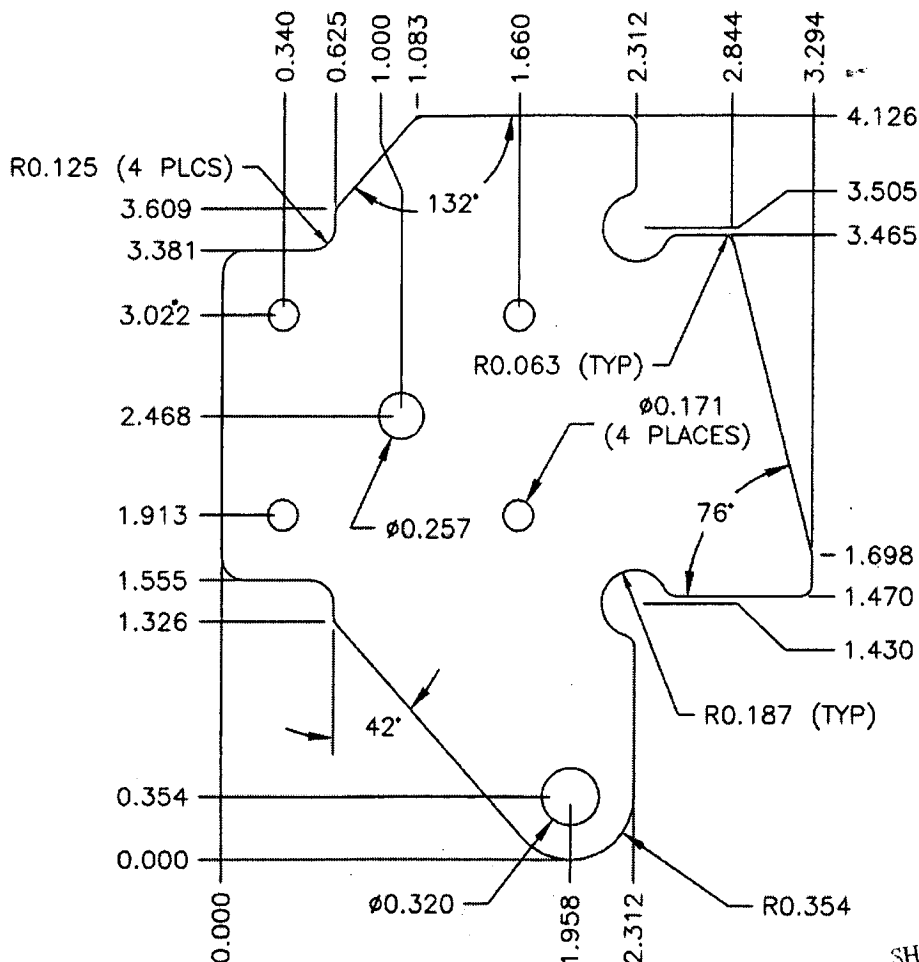
FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28449



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2144	REV. D SHEET 2 OF 2
DATE 98.10.08	TITLE HINGE BRACKET		SCALE 1:1

RELEASED
98.10.15 KB



D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28949

DART AEROSPACE LTD	Work Order:	28949
Description: Hinge bracket, GAS SPRING	Part Number:	D2144
Inspection Dwg: 2144 ... Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article

X	Prototype
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[illegible]

Measured by:	<i>MM MM</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	
Date:	<i>06/10/17</i>	Date:	<i>06/10/20</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	